

5/03  
DART AEROSPACE LTD

Work Order: 22098

Description: Wearshoe

Part Number: D3287-1

Drawing: D3287 Rev. A

Qty: 20

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	JS	04.12.14	20
2	PG	Issue P/O: <u>2005-07-28</u> Email or ship DXF file to vendor Laser Cut D3287-1 Flat pattern as per Dwg D3287 Material release note required	U	04/24/16	20
3	RG	Receive and Inspect for transit damage Ensure the material release note is attached	CL	05/10/15	20
4	QC6	Inspect dimensions as per template D3287-1T1	J	05-08-15	19
5	GB	Deburr if necessary	N/A		
6A	GB	Form on Brake as per Dwg D3287 using Jigs DT8261 and DT8326. Identify as D3287-1	FF	05.08.29	19
7	QC5	Inspect work to Step 6	J	05-06-30	19
8	FP	Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3	FC	05 09 07	19
9	QC3	Inspect Powder Coat	W	05 09 07	19
10	FP	Identify and Stock	W	05 09 07	19
11	AC	Cost / part: <u>1.3.22</u>	S	05-09-08	17
12	DC	Close W/O <u>16.01</u> Inspect Level 21	P	05/09/08	19

Rev	Date	Change	Revised By	Approved
A	04.05.13	New Issue	KJ/DS	

RELEASED  
04.05.13166 | GB | Form Soggle on brake using  
Jig DT 8158 as per Dwg D3287by date  
FF 05.08.29 19

PTO

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05-08-15	4	Tool 1 for Template 03287-1T1	<i>[Signature]</i>	05-08-15	1	<i>[Signature]</i>	<i>[Signature]</i> 05-08-15	
05-08-25	6	Permanent change	<i>[Signature]</i>	05-09-08	1	<i>[Signature]</i>	<i>[Signature]</i> 05-08-25	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: D3287-1 PAR #: 12P Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Dec 13, 2004  
11:38 am

Work Order No : 0022098  
Project Name : D3287-1  
Project For : WK503  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3287-1

Description : Wearshoe  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 12-13-04  
Est Finish Date : 01-20-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00

Order Entry No :  
OE Value : 0.00

Est Margin : 0.000%  
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



New Zealand Steel Limited  
 Glenbrook, South Auckland  
 Postal: Private Bag 92121, Auckland, New Zealand  
 Telephones: (09) 3758 989 Auckland  
 (09) 2558 089 Waiuku  
 Fax: (09) 3758 959 Telex: 24936

# TEST CERTIFICATE

Ref: 3581/12271

CUSTOMER	Wilkinson	P30430N1001	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC072790
CUSTOMER O/N	90-21N-141		PRODUCT	CRA WIDE COIL	PAGE	1 of 1
MILL O/N	375624		DIMENSIONS	0.033" x 48" x Coil	DATE	19 August 2003

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT														MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)											
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ( )	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH			
		x1000														x10000		x100		(180°)				GL =	HRB	( )	(feet)
R9-413484-00	625796	5	TR	20	8	9	12	18	20	1	5	1	1														
R9-413485-00	625796	5	TR	20	8	9	12	18	20	1	5	1	1														
R9-414003-00	625794	5	1	20	8	11	12	18	21	3	6	1	1														
R9-414004-00	625794	5	1	20	8	18	12	18	21	3	6	1	1														

20 GA MS

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (C)=80mm (E)=2" (B)=50mm (D)=5.65 S <sub>0</sub> (F)=8"	PLASTIC STRAIN RATIO (r) (A)=T <sub>0</sub> (C)=F <sub>0.5</sub> (B)=r <sub>90</sub> (D)=(r <sub>0</sub> /(90+2r <sub>45</sub> ))/4	IMPACT TEST (A)=10mm x 10mm (C)=5mm x 5mm (B)=7.5mm x 15mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/5 (B)=C+Mn/8+(Cr+V+Mo)/5+(Cu+Ni)/15	(C)=C+Mn/6+Si/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED  
 WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

*Satish Misra*  
 QC METALLURGIST



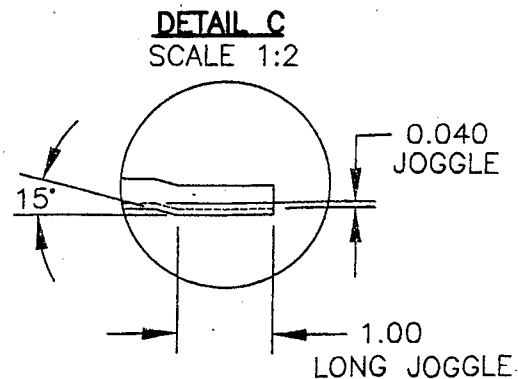
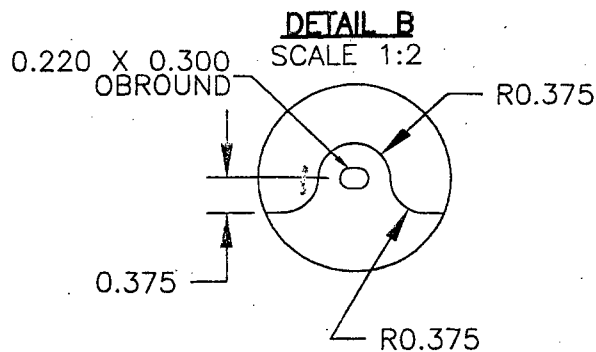
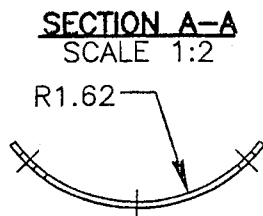
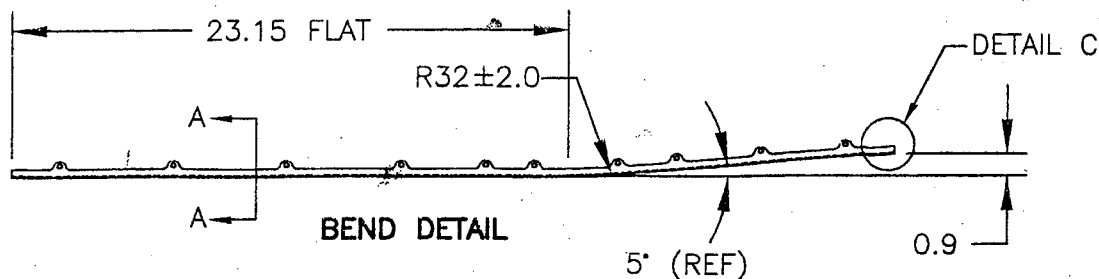
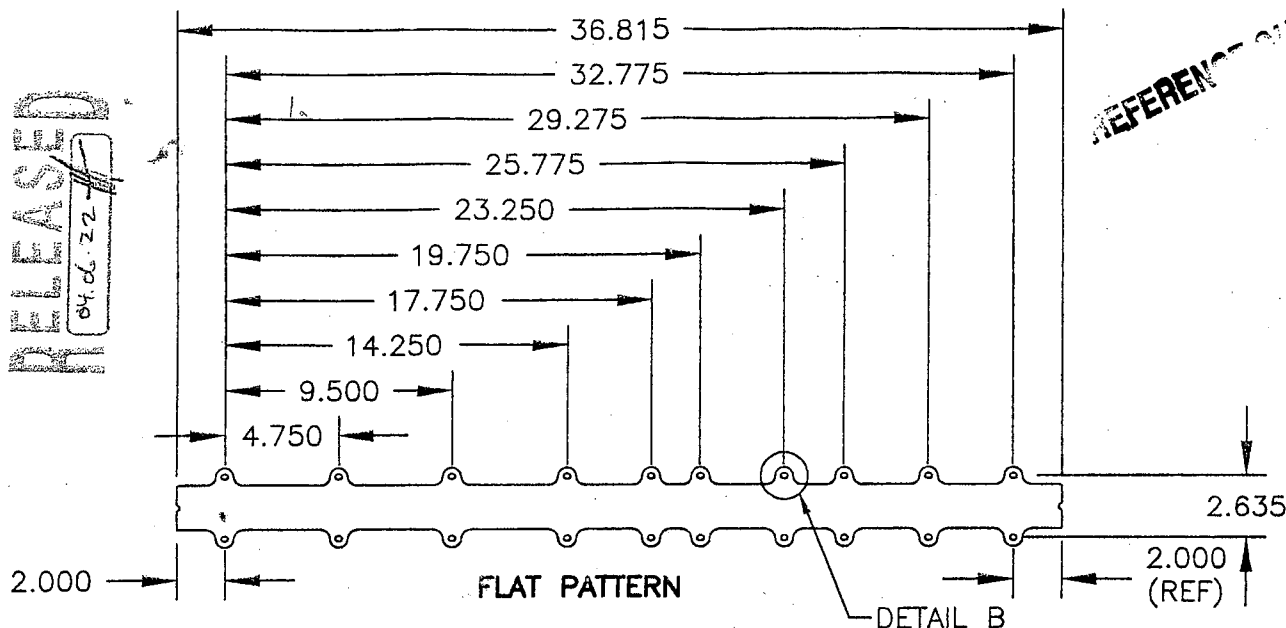
# CONTROLLED COPY



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3287	REV. A SHEET 1 OF 2
DATE 04.05.06		TITLE WEARSHOE	SCALE 1:8
A	04.05.06	NEW ISSUE	

RELEASED  
04.06.22

REFERENCE



## D3287-1 WEARSHOE

- 1) MATERIAL: AISI 1000 SERIES STEEL  
20 GAUGE (0.040 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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